

19-7791



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

269T9259-7
Job Sheet 202609



Part No: 269T9259-7

Job Qty: 3 pcs

Part Name: Anvil



10 pcs.

DAS
21
9-89

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/19

Job Tracking No:

Due Date: 12/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 269T9259 Rev 2 IPP Rev. A 19.10.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-154 - 1	3 pcs	12/6/19	12/6/19	1.00	0.20	SL-154 - 1		JB 19-11-27
130	QC 2	3 pcs	12/6/19	12/6/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB 19-11-27
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 (613) 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S235518



Part: 269T9259-7

Job No: 202609

Serial No/Batch: S235518

Revision: 2

Inspector:

Eva Date:

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P.T.O.

DAS
62
9-89DAS
62
9-89

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140 NV5000 - 1 - B4B	3 pcs	12/6/19	1.00 0.30	NV5000 - 1 - B4B	J.S.C.L. 19-11-28
				NV5000 - 2 - B4B	
150 QC 2	3 pcs	12/6/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	J.S.C.L. 19-11-28
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
160 QC 8	3 pcs	12/6/19	0.00 0.00	QC 8 - 12	J.S.C.L. 19-11-28
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	

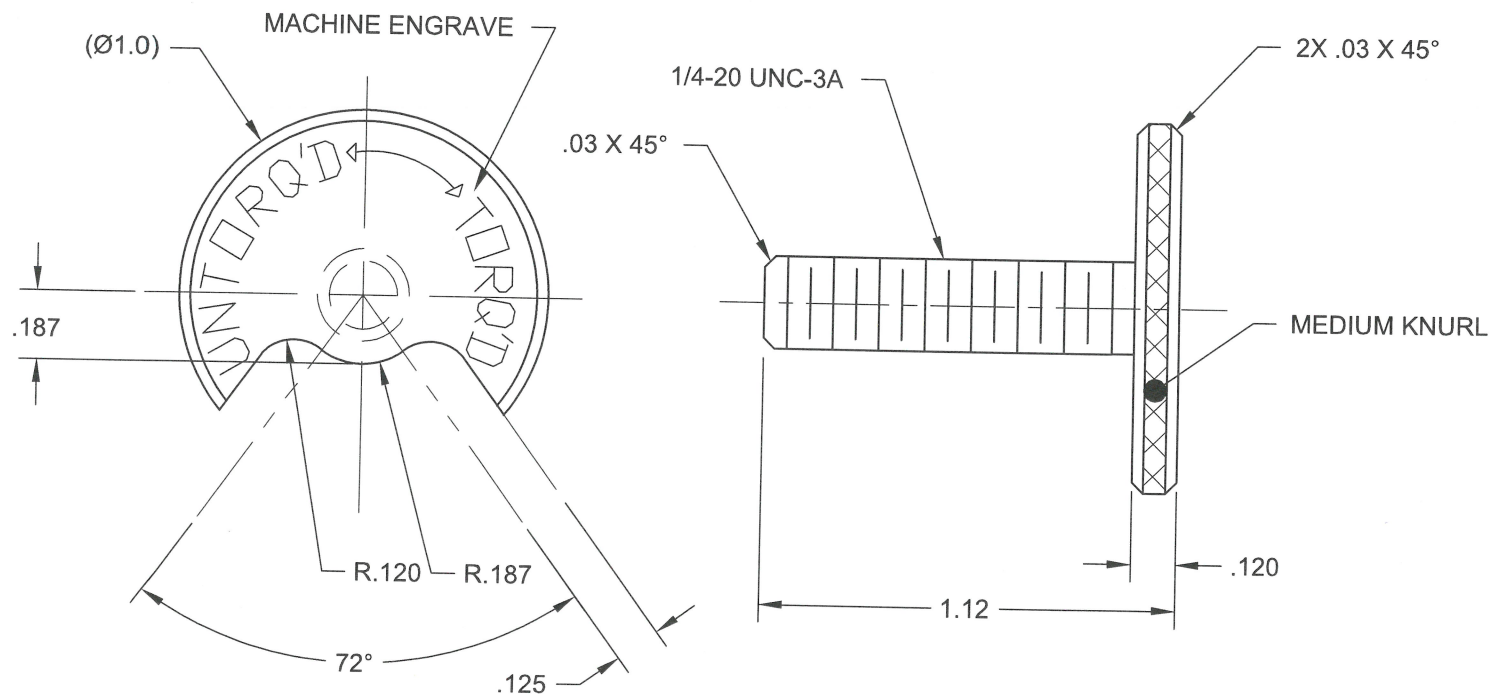
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
170	Packaging 3-1 - Stock - B4B 3 pcs	12/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	23
				Packaging 3 - 8 - B4B	9-30
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA 3 pcs	12/6/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-30
Part Op 120 - 1-Machine as per folio FO 100 FOLIO REV: AA DWG REV: 2 2-Deburr Descriptions: 130 - QC2- Inspect parts off machine FAI/FAIB 140 - 1-Machine as per folio FO 100 FOLIO REV: AA DWG REV: 2 2-Deburr 150 - QC2- Inspect parts off machine FAI/FAIB 160 - QC8- Inspect parts - second check 170 - Identify as per dwg & Stock Location: 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R1.000	303 Round Bar 1.00	.3123 ft (.1041 ea)	120-SL-154 - 1	5221910	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	M303R1.000	0	8	0
Part Specifications				
Specifications could not be found.				

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
2	-7 CH'D DIM WAS Ø1.000 IS (Ø1.0), ADDED MISSING DIM .03 X 45°.	5/1/14	DPD
			GE



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 202609 M45
19-10-31

(-7)
ANVIL

RED BARN MACHINE	
TITLE MICROMETER LEAD LAG & FLAPPING	
DWG NO. 269T9259-7	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
.XXX ± .010	ANGLES ± 5°
.XX ± .030	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 10-8-09
SHEET 4 of 5	
DRAWN BY: CLOUGH	
APPROVED: <i>D. Weil</i>	
HEAT TREAT FINISH	
SPEC	
USED ON MODEL	
SCHWEIZER	

Entered: ALADate: 19-11-28

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7791Route update only ☐

Job: <u>202609</u> Part No. <u>269T9259-7</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>19-11-28</u>	Sequence #: <u>140</u>	QTY Affected: <u>1</u>	MRB (QSI042) DAS 9 9-89 <u>19-11-28</u>
Description Work Order Deviation		Disposition	
<u>BROKEN Endmill make big MARKS on PART</u>		<u>Scrap no replace</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ ☒ Broken/Damage/Defect Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		FAULT CATEGORY Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details:			